

Date: Thursday, 25/09/2008 10:50:56 AM  
User: Melanie Fauteux

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: AFT BLADE FOLD ASSEMBLY
Job Number	: 41291 - 1		
Estimate Number	: 13532		
P.O. Number	:	Part Number	: PB674300103
This Issue	: 25/09/2008 S.O. No. :	Drawing Number	: B6743001 P.1,3,4,15
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 18/08/2008 Type : SMALL /MED FAB	Drawing Revision	: B1
Previous Run	: 41239	Material	:
Written By	:	Due Date	: 15/09/2008
Checked & Approved By	: <u>mf 08-09-25</u>	Qty:	<u>split 2</u> Um: Each
Comment	: Est Rev:A 08-07-30 new issue DD verified by:ec		

## Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

PB674300109

Aft Blade Fold Assembly Weldment



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Aft Blade Fold Assembly Weldment

batch: 42000 42154mf 08-10-30

2.0

PB674300113

Aft Adjustable Blade Support Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Aft Adjustable Blade Support Assembly

batch: 40607 x 2mf 08-10-24

3.0

PB674300117

Aft Adjustable Blade Support Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Aft Adjustable Blade Support Assembly

batch: 40609 x 2mf 08-10-24

4.0

PB674300121

PB67-43001-21



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

PB67-43001-21

batch: 41370mf 08-10-24

5.0

PB674300123

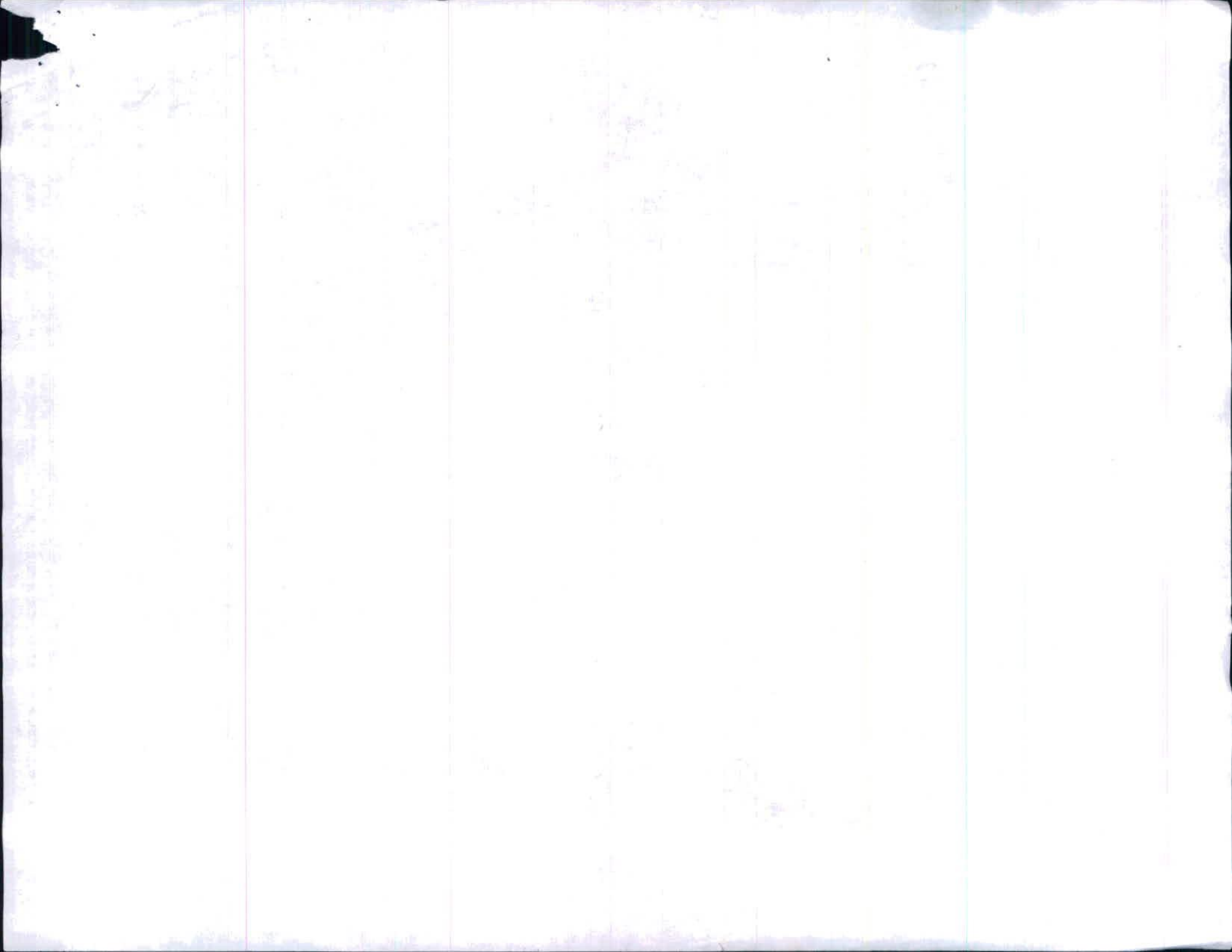
PB67-43001-23



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

PB67-43001-23

batch: 41371 342972 - 1mf 08-10-24





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Part Number: PB674300103

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PB674300137

PB67-43001-37



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

PB67-43001-37

batch: 41379

mf 08-10-21

7.0

PB674300157

Stabilizer Arm



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Stabilizer Arm

batch: 841014

mf 08-10-24

8.0

PB674300159

PB67-43001-59



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

PB67-43001-59

batch: 41383

Sawa

mf 08-10-24

9.0

PB674300163

Handle Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Handle Assembly

batch: 41384

mf 08-10-24

10.0

PB6743001135

Male Eye



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Male Eye

batch: B 239954

mf 08-09-25

11.0

PB6743001155

Pin



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pin

batch: B 41906 x 4

mf 08-09-25

12.0

PB6743001261

Lever Arm

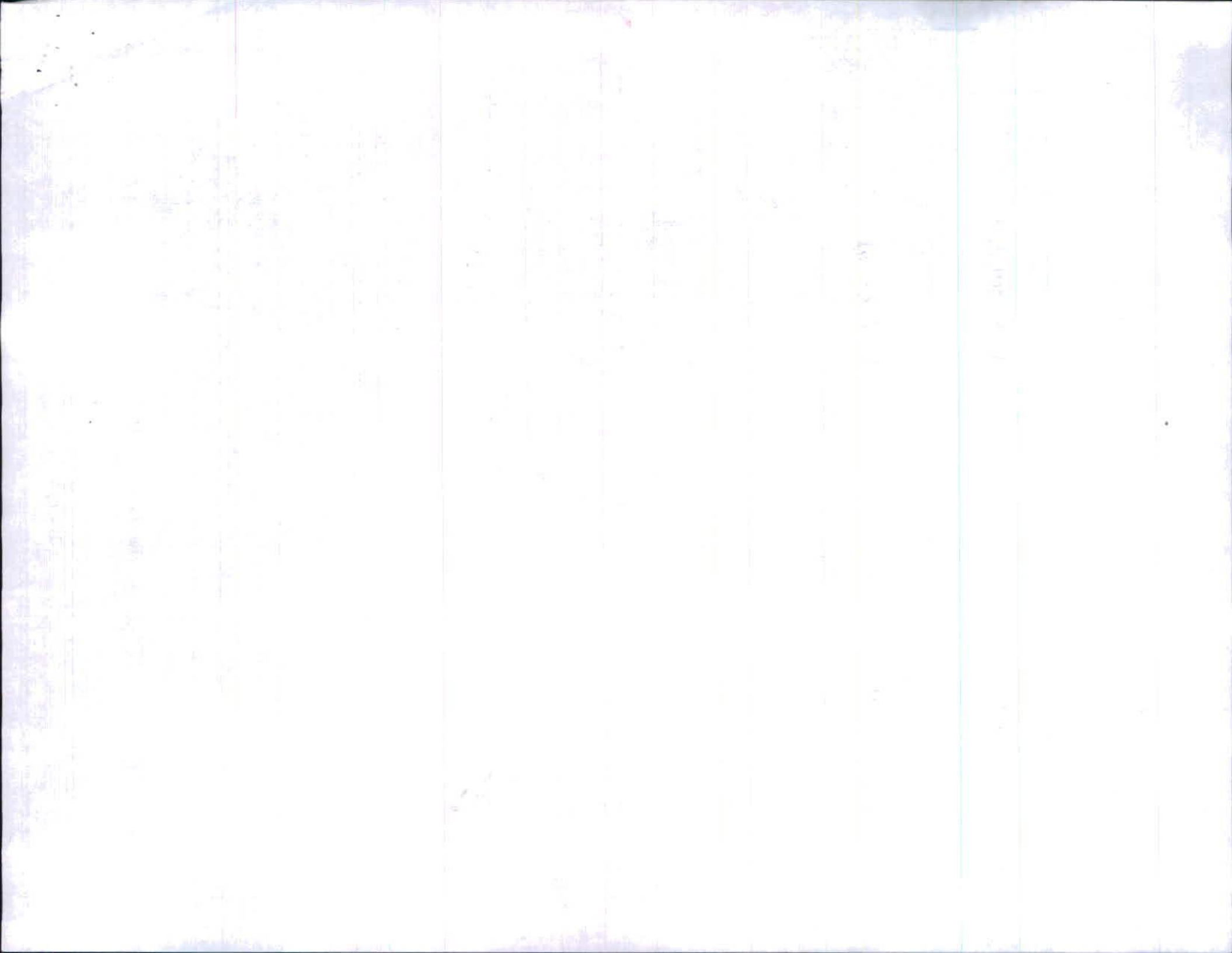


Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Lever Arm

batch: B 41294

mf 08-09-25





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Job Number: 41291

Part Number: PB674300103

Job Number:



Seq. #:	Machine Or Operation:	Description :
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13.0	PB6743001265	Bushing
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Bushing

batch: B41373

MF 08-09-25

14.0	PB6743001299	Bushing
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Bushing

batch: B40062

MF 08-09-25

15.0	D3451045	Handle and Lock-Down Assembly
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Handle and Lock-Down Assembly

batch: B41065 x2mx

MF 08-09-25

16.0	D3451043	Handle and Lock-Down Assembly
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Handle and Lock-Down Assembly

batch: B41064 x2mx

MF 08-09-25

17.0	D34401	Tube Guide (Supersedes B67-43001-25/-307)
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Tube Guide

batch: B41347

MF 08-09-25

18.0	D34403	Clamp (Supersedes B67-43001-309)
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Clamp

batch: B41277

MF 08-10-29

19.0	D34441	Velcro Loop Belt
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Velcro Loop Belt

batch: B39965

MF 08-10-29

1911

1911

1911

1911



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Job Number: 41291

Part Number: PB674300103

Job Number:



Seq. #:	Machine Or Operation:	Description :
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20.0	D34479	Swing Arm
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Swing Arm

batch: 841352

*mf* 08-10-29

21.0	086004	Inventory
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Inventory

batch: m17850

*mf* 08-10-29

22.0	MS27039107	Screw
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Screw

batch: m108057

*mf* 08-10-29

23.0	MS27039123	SCREW
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

SCREW

batch: m18057

*mf* 08-10-29

24.0	MS21042L4	Nut
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Comment: Qty.: 13.0000 Each(s)/Unit Total: 52.0000 Each(s)

Nut

batch: m104683x10, m107499x19, m108552x15, m105054x8

*mf* 08-10-29

25.0	MS21042L6	Nut
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Comment: Qty.: 4.0000 Each(s)/Unit Total: 16.0000 Each(s)

Nut

batch: m108183x5, m105077x11

*mf* 08-10-29

26.0	MS518596	WASHER
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Comment: Qty.: 8.0000 Each(s)/Unit Total: 32.0000 Each(s)

WASHER

batch: m17890x4, m108986x20, m108473x8

*mf* 08-10-29





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Job Number: 41291

Part Number: PB674300103

Job Number:



Seq. #:	Machine Or Operation:	Description :
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27.0	MS518598	WASHER
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Comment: Qty.: 8.0000 Each(s)/Unit Total : 32.0000 Each(s)

WASHER

batch: m108986

*MF 08-10-29*

28.0	NAS43DD368	SPACER
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

SPACER

batch: m109060

*MF 08-10-29*

29.0	NAS1149F0316P	WASHER
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

WASHER

batch: m108473

*X*

*MF 08-10-29*

30.0	NAS1149F0432P	Washer
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Comment: Qty.: 16.0000 Each(s)/Unit Total : 64.0000 Each(s)

Washer

batch: m18057

*MF 08-10-29*

31.0	NAS1149F0632P	WASHER
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Comment: Qty.: 8.0000 Each(s)/Unit Total : 32.0000 Each(s)

WASHER

batch: m18057

*MF 08-10-29*

32.0	NAS1149F0832P	WASHER
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

WASHER

batch: m18057

*MF 08-10-29*

33.0	AN960JD6	Washer
------	----------	--------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

batch: 6085

*MF 08-10-29*



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Job Number: 41291

Part Number: PB674300103

Job Number:



Seq. #:

Machine Or Operation:

Description :

34.0

AN410A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Bolt

batch:

m105442 x 5, m101291 x 1, m107178 x 2.

*MF 08-10-29*

35.0

AN413A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

batch:

m109282

*MF 08-10-29*

36.0

AN416A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Bolt

batch:

m19278

*MF 08-10-29*

37.0

AN611A

BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

BOLT

batch:

m105558

*MF 08-10-29*

38.0

AN620A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Bolt

batch:

m104547

*MF 08-10-29*

39.0

AN813A

BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

BOLT

batch:

m108986 x 2, m18180 x 6

*MF 08-10-29*

40.0

BSP43

RIVET



Comment: Qty.: 3.0000 Each(s)/Unit Total : 12.0000 Each(s)

RIVET

batch:

m109119

*MF 08-10-29*





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Part Number: PB674300103

Job Number:



Seq. #:

Machine Or Operation:

Description :

41.0

CR3213405

cherry rivet



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

cherry rivet

batch: m104214

mf 08-10-29

42.0

MS17984C413

PIN, QUICK RELEASE



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

PIN, QUICK RELEASE

batch: m18119 x 3, m108986 x 1

mf 08-10-29

43.0

MS17984C418

PIN, QUICK RELEASE



Comment: Qty.: 3.0000 Each(s)/Unit Total: 12.0000 Each(s)

PIN, QUICK RELEASE

batch: m108986

mf 08-10-29

44.0

30345T21

LANYARD



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

LANYARD

batch: m107827

mf 08-10-29

45.0

30345T24

LANYARDS



Comment: Qty.: 3.0000 Each(s)/Unit Total: 12.0000 Each(s)

LANYARDS

batch: m108390 x 9, m108913 x 3

mf 08-10-29

46.0

240107

SPRING SLOTTED PIN



Comment: Qty.: 9.0000 Each(s)/Unit Total: 36.0000 Each(s)

SPRING SLOTTED PIN

batch: m102940 x 30, m17850 x 6

mf 08-10-29

47.0

3408A98

DETENT BALL SPRING PLUNG

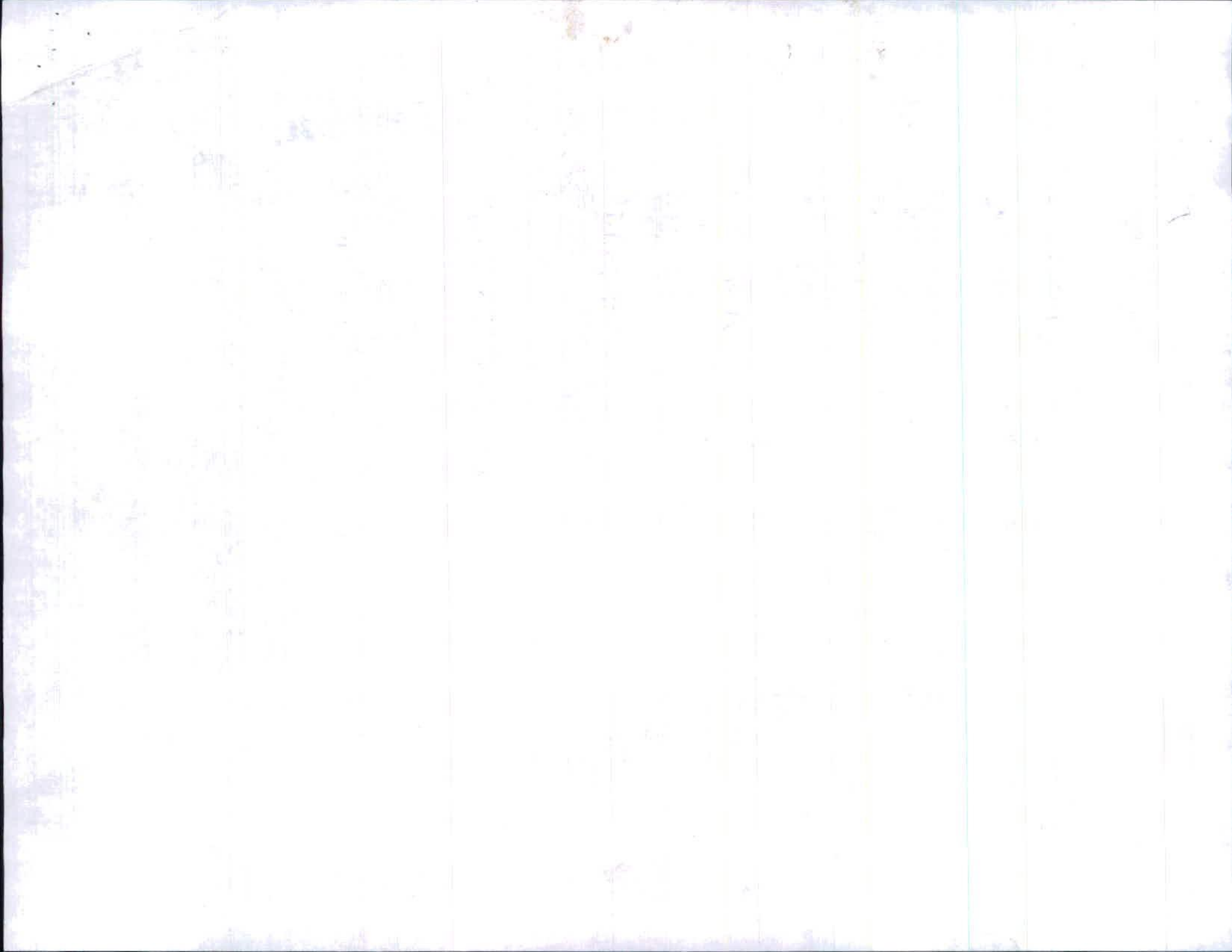


Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

DETENT BALL SPRING PLUNG

batch: m102912 x 3, m17828 x 1

mf 08-10-29





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Job Number: 41291

Part Number: PB674300103

Job Number:



Seq. #:

Machine Or Operation:

Description:

48.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Assemble as per dwg and use 242 threadlock A/R shown on dwg PB67-43001 page 2.

242 THREADLOCK batch: m109687

SAD

F2/M- 08/10/29

(2)

49.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/10/29 (2)

50.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock  
Location: \_\_\_\_\_

PPP 41184 PPP 41183

Ref/30 (2)

51.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/10/30

Job Completion



~~47.1~~ - Add B 6743001-305 <sup>name B 42915</sup> B 40063 x1, MF 08-10-29  
B 42655 x1  
47.2 - Add D3449-1  
B 41617 x2: MF 08-10-29  
MF 08-10-30



REV STATUS OF SHEETS	REV SHEET	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41	42	43	44	45	46	47	48	49	50	51	52	53	54	55	56	57	58	59	60	61	62	63	64	65	66	67	68	69	70	71	72	73	74	75	76	77	78	79	80	81	82	83	84	85	86	87	88	89	90	91	92	93	94	95	96	97	98	99	100
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REVISIONS			
REV	DESCRIPTION	DATE	APPROV
1	MFG. REFEST	10/12/95	WH
2	A CHANGES TO IMPROVE FUNCTIONALITY	3/7/96	WH
3	OWG AND P/L REVISED AND UPDATED	6/16/96	WH
4	TO REFLECT BELL MODIFICATIONS		
5	CHANGE DESIGN AFTER RPT	3/26/95	
FUNCTION: TEST CASE 17-DWG 400-1			

21. SECURE -43 BELT ASSY TO TOP OF -65 101 -651 OR -47 101 -673.  
LOCATE APPROX AS SHOWN.
22. WITH -137 SCREW IN OPEN POSITION, LOCATE RIVET  
APPROX AS SHOWN, TO SERVE AS A STOP FOR -137.
23. DRILL WITH -37 AT VERTICAL FULL OPEN POSITION.  
DRILL ADDITIONAL HOLE WITH -37 AT FULL CLOSED POSITION,  
ASSURING -37 CLEARS ADJACENT STRUCTURE.
24. SHIM AS REQD, USING N1149D0332J WASHERS.
25. -81 FWD BLADEFOLD ASSY FOR COMMERCIAL VERSIONS ONLY  
-82 FWD BLADEFOLD ASSY FOR CANADIAN VERSIONS ONLY
26. TOLERANCE ON DECIMAL  $\pm .1$
27. LAST SECTION LETTER USED "L".
28. DRILL NO. 30 (1.281) HOLE THRU -37 AND AND -25 (COMPONENT  
OF -37 ASSY), INSERT 803073 SET PIN, AND GRIND FLUSH  
WITH -37.

- REFERENCE ONLY**

- ⚠ NO PAINT REQUIRED. CHEM FILM ONLY WHERE APPLICABLE.  
PER PREMIER SPEC 008-93003
- ⚠ STITCH APPROX AS SHOWN, PER FED-STD-751.
- ⚠ PERMISSIBLE TO TRIM NYLON WASHERS OR SUBSTITUTE WITH  
THINNER #551858 EQUIVALENT.
- ⚠ DISASSEMBLE -53 HANDLE ASSY (BOTH SIDES) PRIOR TO INSTALLATION  
AND REMOVAL OF -01 OR -02 BLADEFOLD ASSY TO AIRCRAFT

SEE SEPARATE PARTS LIST B67-43001PI

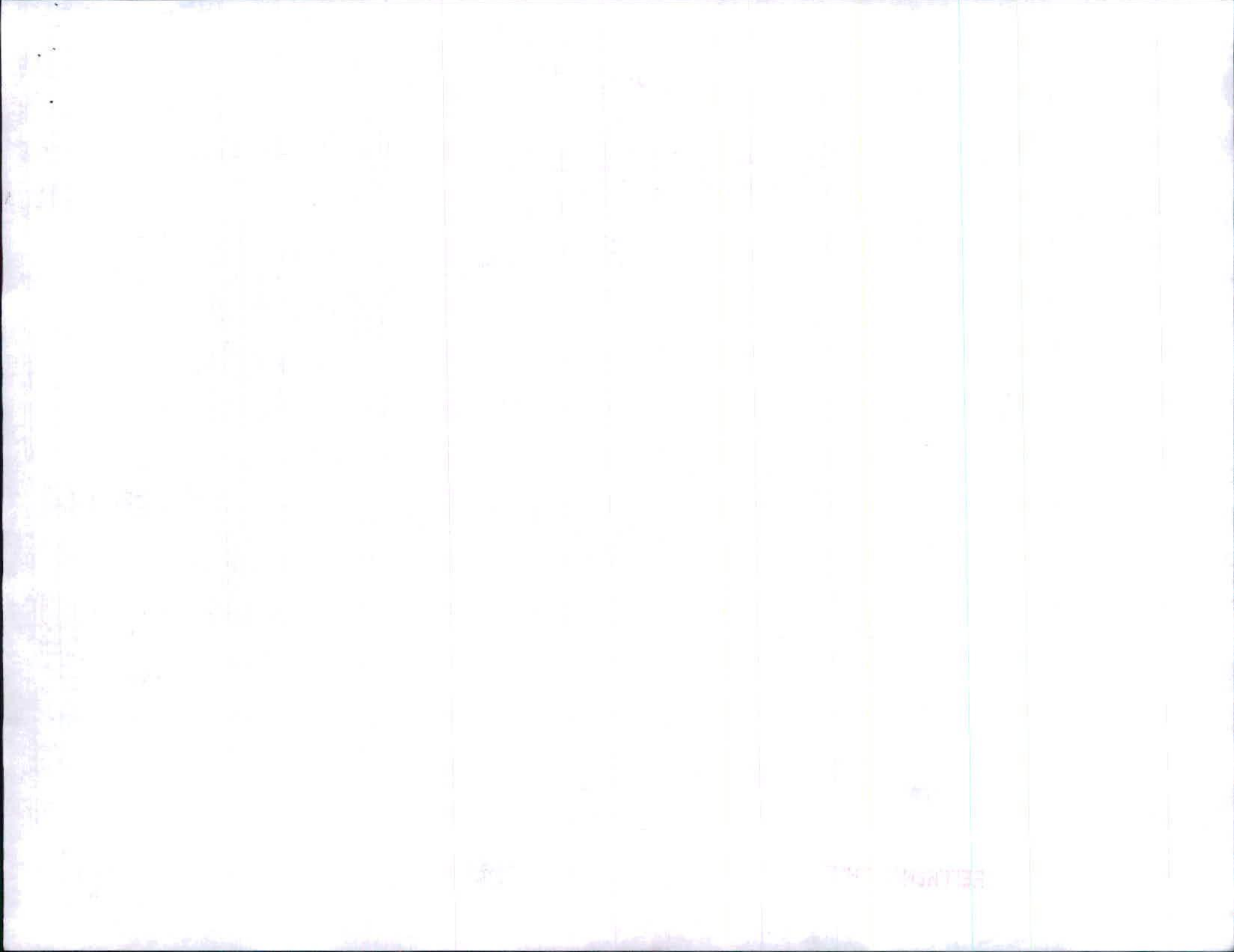
[illegible]

ORIGINAL



REFERENCE ONLY





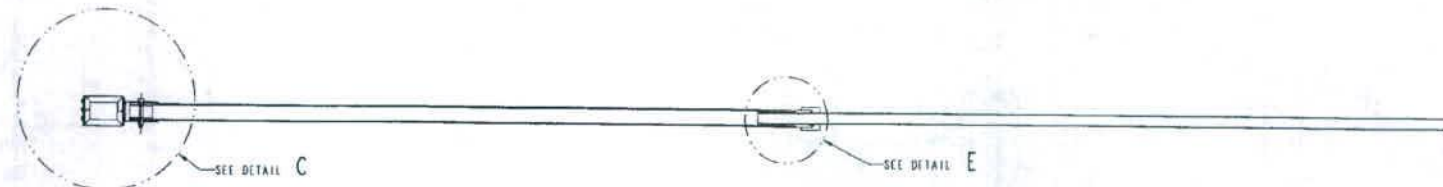


RELEASED  
Cl. 11. 2

8 7 6 5 4 3 2 1

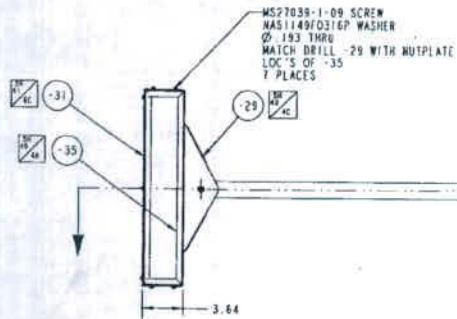
D

D



C

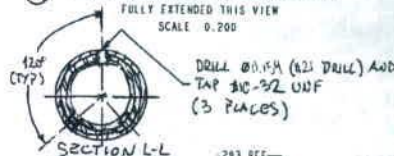
C



B

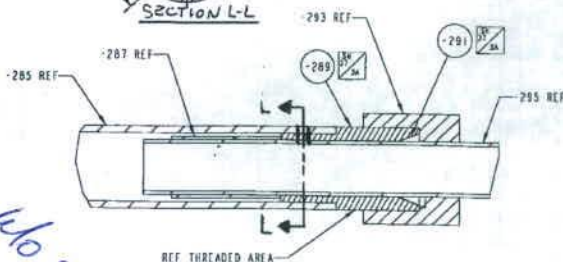
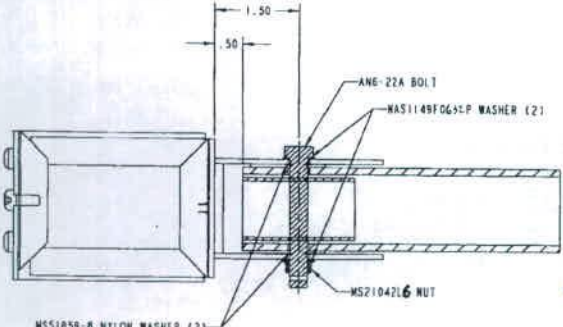
B

### -27 BLADE POSITIONER



A

A



DETAIL C  
SCALE 1.000  
(1-27 ASSY)

DETAIL E  
SCALE 1.000  
(1-27 ASSY)

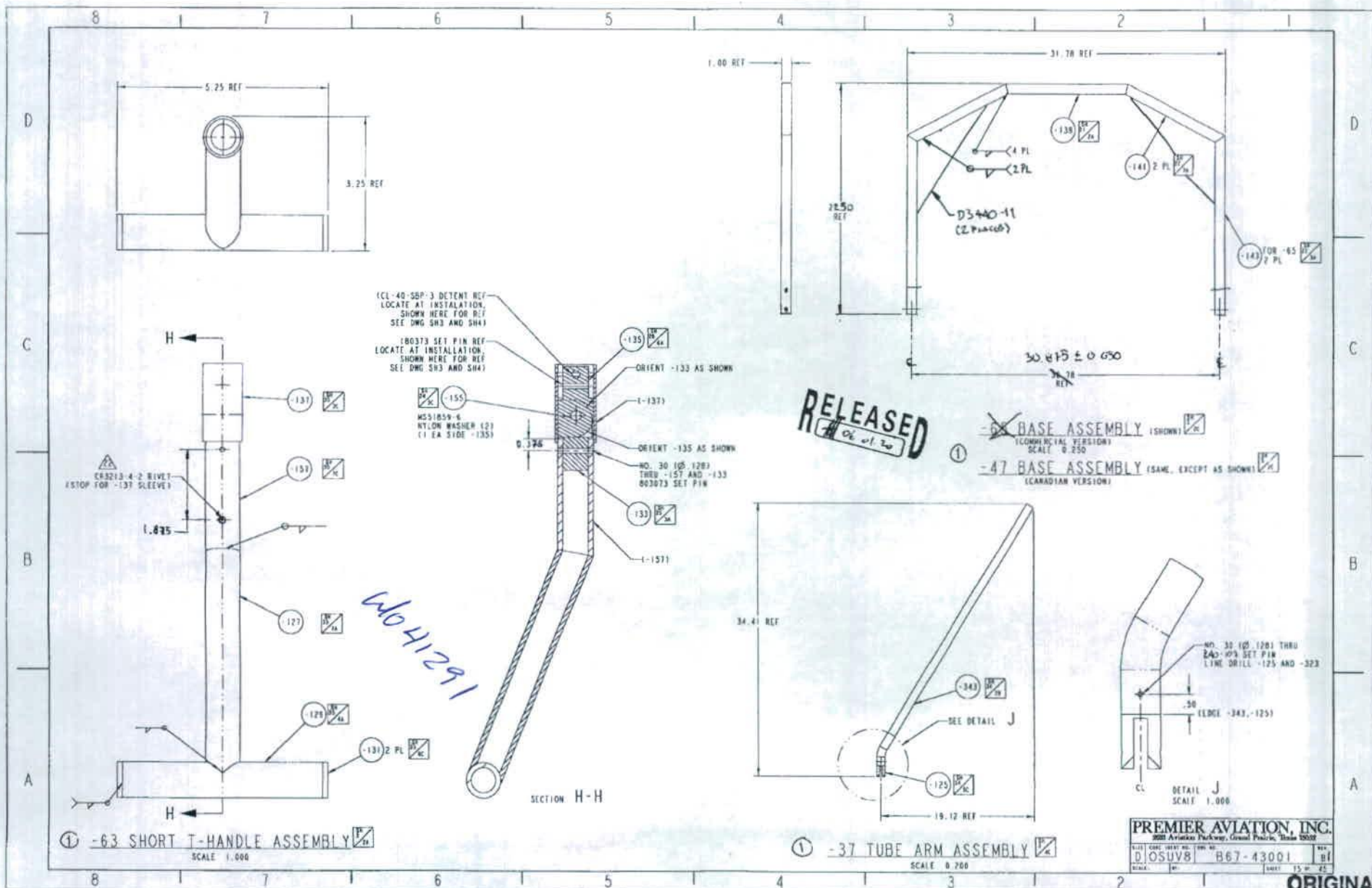
DETAIL B  
SCALE 2.000  
(1-03 ASSY)

PREMIER AVIATION, INC.  
800 Aviation Parkway, Grand Prairie, Texas 75052  
D105UV8 B67-43001

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